

Work Order ID 81462

Wednesday, March 14, 2012 11:01:52 AM

81462

Page 1

Item ID: D4148-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Assembly, Fwd
 Start Date: 3/14/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-03-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								

100 0.00
100
 Small Fab Memo 0.00
 Small Fab 1- Assemble as per dwg

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

120 Identify as per dwg & Stock Location: ST 468 0.00
120
 Packaging Memo 0.00
 Packaging

Handwritten signature and date: 12/04/10 @

Handwritten circled number: 16

Handwritten initials and date: 12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81462***81462***

Page 2

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Item ID: D4148-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/4/12 J

R120411

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Picklist Print

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Page 1

Work Order ID: 81462

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
 IPP Rev:B 10.07.22 as per revB DD verf:JLM
 DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC
 IPP Rev:C 10.10.29 as per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No			100	Each	836.0000	4	12		3/12/04/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		72							
				103691		72							
				GA		334							
				120693		334			12				
				ST301		430							
				118077		2							
				118614		378							
				118686		30							
				119758		20							
MS21043-4 Nut		Purchased	No			100	Each	1,193.0000	1	18		3/12/04/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		40							
				104603		40							
				ST301		1153							
				119546		415			18				
				120308		738							
D2690-6 Lanyard Assembly		Manufactured	No			100	Each	27.0000	1	6		3/12/04/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST016		27							
				79515		27			6				

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Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

D3910-1
Crosstube Lug

Manufactured No

100 Each 15.0000

1 6

Location

Loc Qty

Loc Code

st507

15

78326

15

D4091-1
Mounting Lug

Manufactured No

100 Each 24.0000

1 6

Location

Loc Qty

Loc Code

ST458

24

81005

24

D4148-1
Crosstube Lug Plate, Fwd

Manufactured No

100 Each 23.0000

2 12

Location

Loc Qty

Loc Code

ST132

23

78331

23

D4148-3
Stud Receiver, Lower

Manufactured No

100 Each 8.0000

1 6

Location

Loc Qty

Loc Code

ST133

8

79055

8

D4148-5
Eyebolt Stud

Manufactured No

100 Each 5.0000

1 6

Location

Loc Qty

Loc Code

ST133

5

78330

5

3/12/04/10
B81474

3/12/04/10

3/12/04/10

B81477 (12x)
3/12/04/10

B81478 (6x)
3/12/04/10

B81405 (6x)

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Page 3

Work Order ID: 81462

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

AN3C12A
Bolts Purchased No

100 Each 324.0000 2 12

Location	Loc Qty	Loc Code
GA	50	
120449	50	
ST351	274	
117514	4	
118112	5	
118451	22	
119510	1	
120423	242	

AN4C13A
BOLT Purchased No

100 Each 130.0000 3 18

Location	Loc Qty	Loc Code
ST357	130	
120187	1	
120423	129	

MS17984-C413
PIN, QUICK RELEASE Purchased No

100 Each 18.0000 1 6

Location	Loc Qty	Loc Code
ST315	8	
114340	1	
118612	2	
120360	5	
ST333	10	
121011	10	

~~MS~~ MS20615-4M18
Rivet Purchased No

100 Each 314.0000 8 48

Location	Loc Qty	Loc Code
ST323	314	
118077	150	
118543	164	

Wednesday, March 14, 2012 11:01:51 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Page 4

Work Order ID: 81462

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0332R

Purchased

No

100

Each

3,617.0000

4

24

Washer

Location

Loc Qty

Loc Code

ST297

3617

118354

551

119736

196

120648

2870

NAS1149C0432R

Purchased

No

100

Each

2,618.0000

6

36

Washer

Location

Loc Qty

Loc Code

ST297

2618

117291

1618

119124

1000

GP 3/12/04/10
M121255 (24K)

GP 3/12/04/10
36

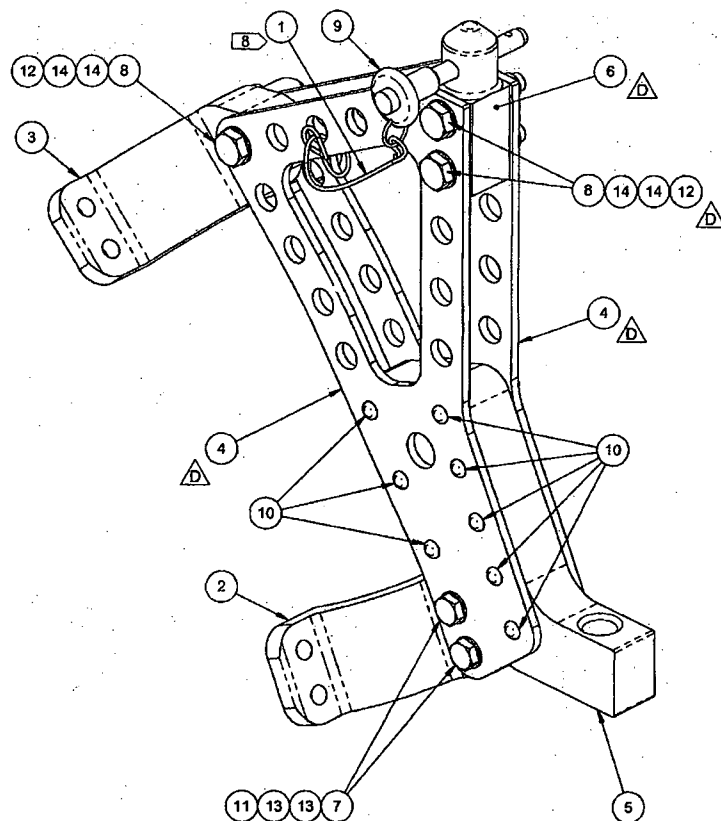
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.262" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1,C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-501 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20815-4M18 WITH QTY(2) EACH AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20815-4M18 WAS MS20815-4M20 (ZN D3-1 & B7-2); Ø0.129 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-407-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. D
SHEET 1 OF 5

TITLE **FWD X-TUBE LUG ASSY** SCALE
NTS

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Dart Aerospace Ltd

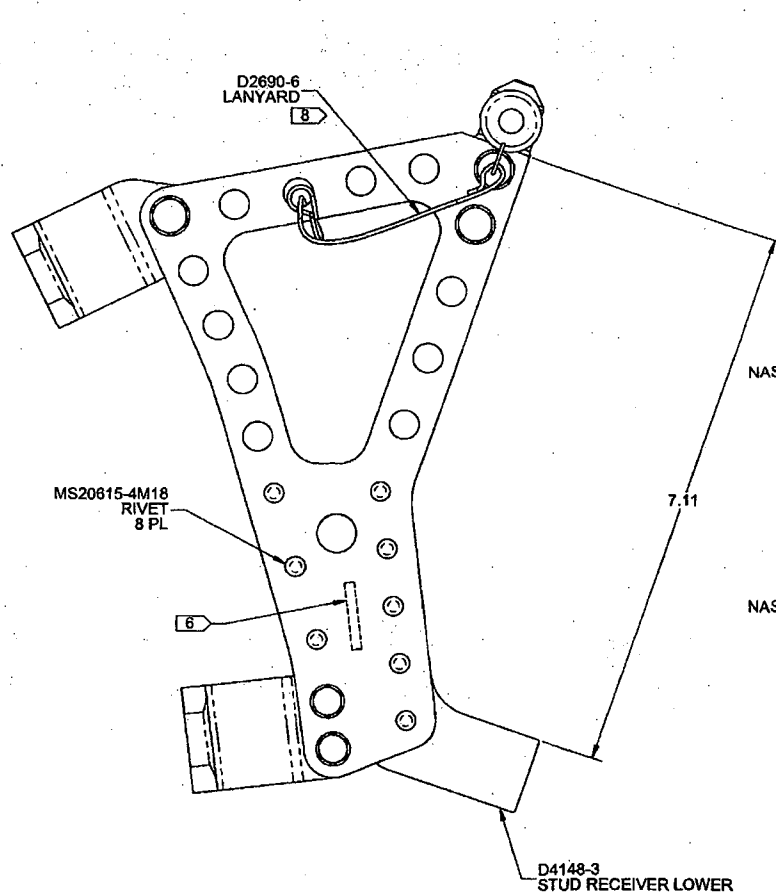
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

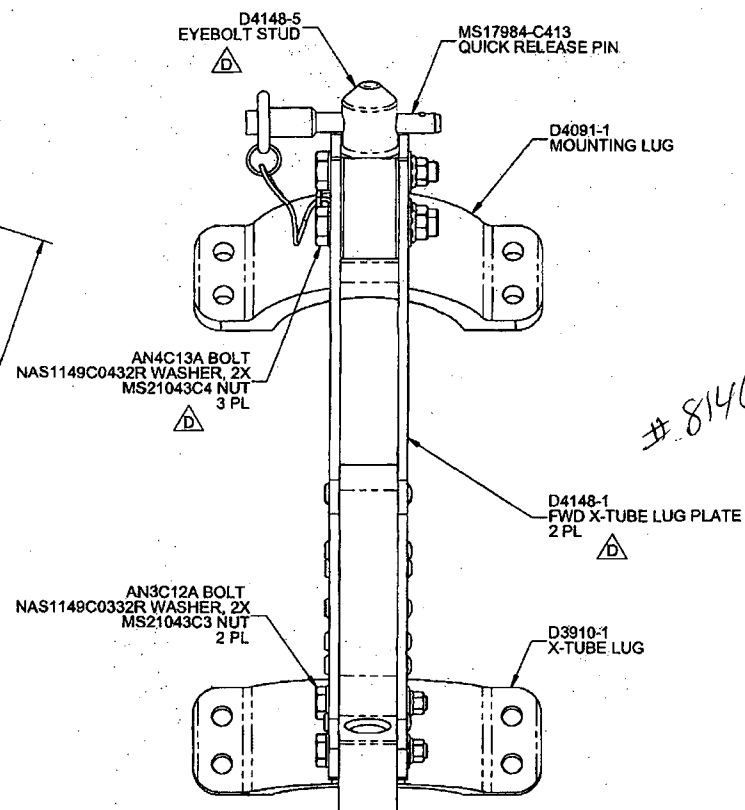
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY



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2011-02-24

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
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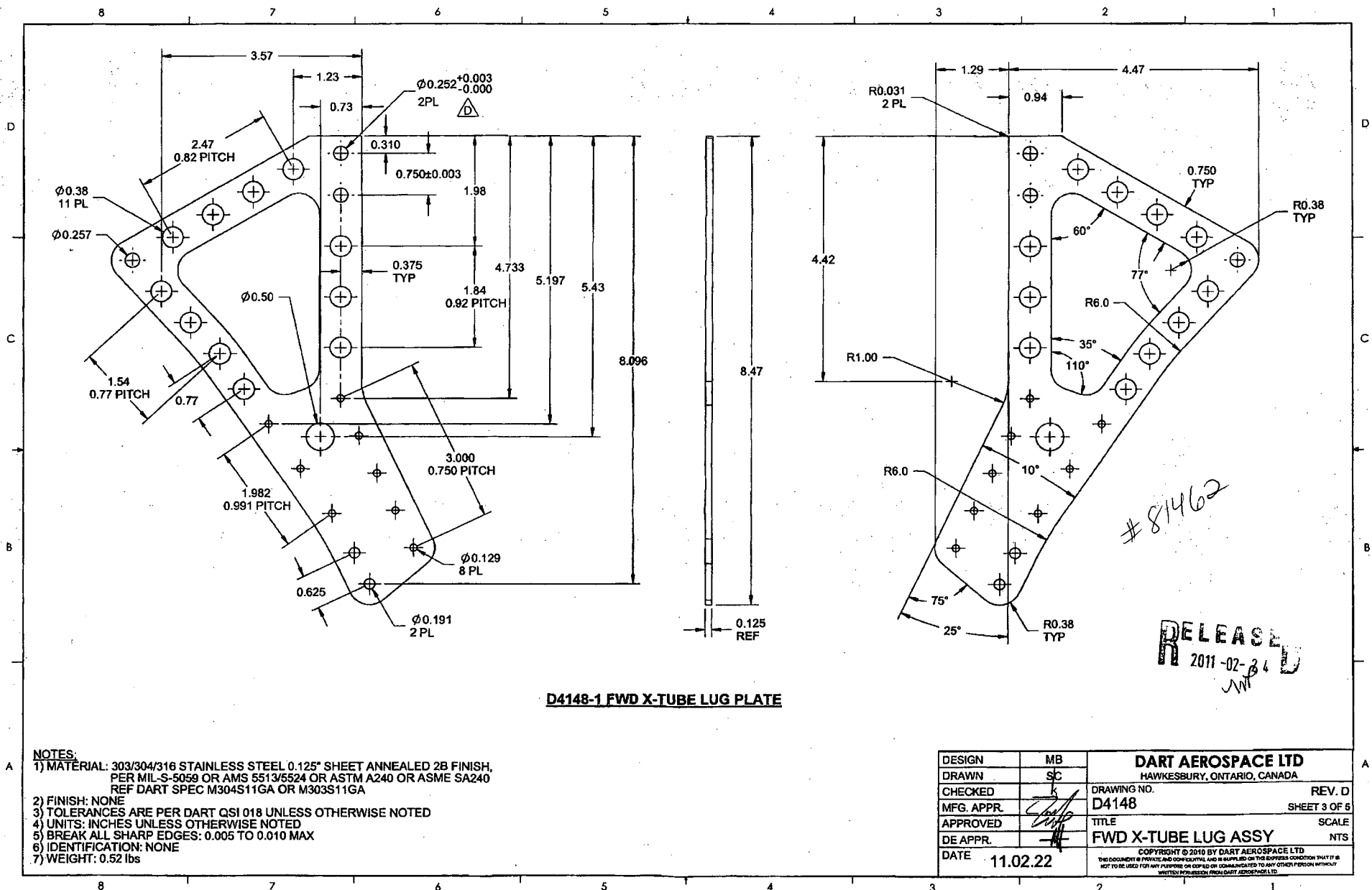
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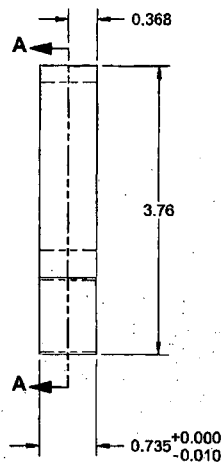
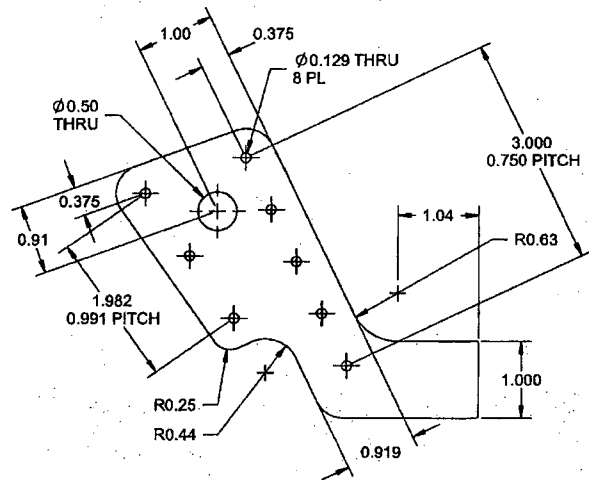
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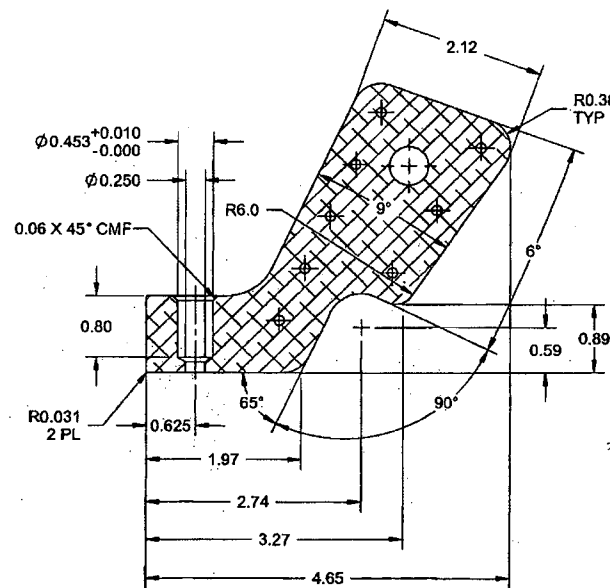
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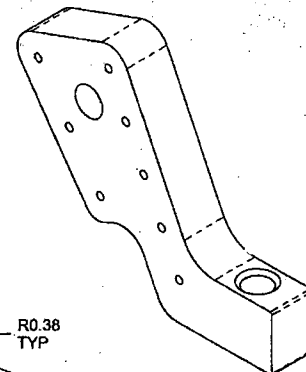
NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER



SECTION A-A



#81462

RELEASED
2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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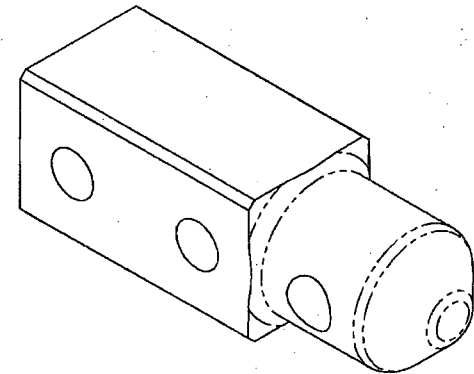
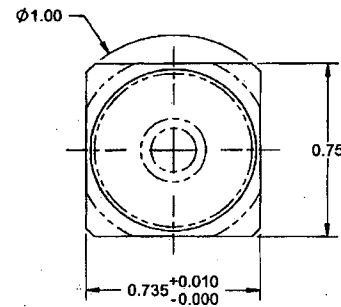
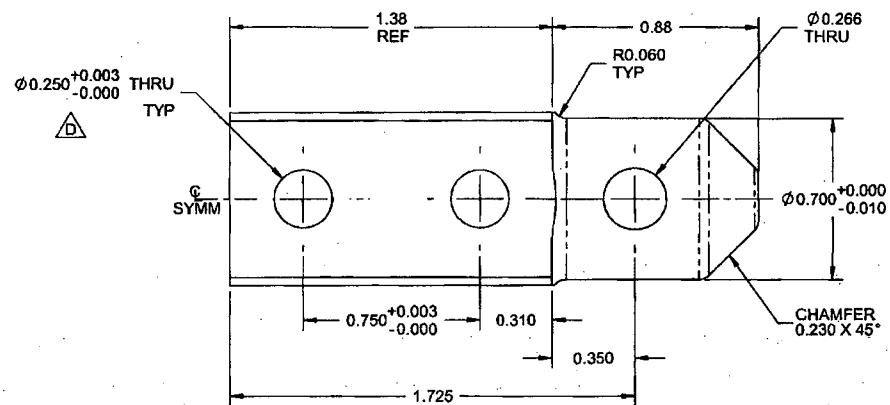
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NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

#81462

RELEASED
2011-02-24
JW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	JW	D4148	SHEET 5 OF 5
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